Work Orde Wednesday, Septe				*90!	577*			Sh	W (bdar	Page 1
Revision ID: Item Name:	D412-698-03 Door Handle 9/19/2012	•	+4+	Accept	*N900		100)* s	Setup Star	i Zi	S1* S2*
Required Date: 9 Reference:		Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item Customer:				15t	十 (
		n:_ W	Date: \209/	Tooling: SPC (Y/N):		Pate:		F	Run Stai Stoj	I <i>/</i> I	R1* R2*
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Tool ID		Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr		ision Nbr									1
IIN D412-698	Rev	Е									
100 DC Document Control		DOCUMENT CONTRO Memo Photocopy b	DL bluefile & type labels per	0.00 0.00 PPP D412-698-032	CHG001 J B				MLJ	1241	<u>19-19</u>
. 110		Pick Kit		0.00							
110 Packaging Packaging		Memo		0.00							17/09/19 JB
120	•	QC4- 100% Inspect kits	for completeness	0.00							
120 QC Quality Control		Memo		0.00) 12/5/19			(40-			

			DQA: _	Dat	re:
VICR.	Ves / No	WORK ORDER NON-CONFORMANCE / LIPDATE			

											QA Closed:	Dat	te:	
Work Ord	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
Part I	No.					Rework Scrap Use-as-is Work Order Update			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	-1	Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other
Root					Descri	ption of work order update		nitial	Ac	tion	Sign &			
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	cription	Date	Verificatio	n	QC Inspector
Doc/Data														
Equip/Tooling														
Operator														
Material														
Setup														
Other														
Process														
Supplier														
Training														
Unapproved				<u> </u>									\perp	
						<u> </u>	AUL	T CATE	GORY					
Landi		7			_	General		I		_	7			
	-	Bending			ļ	Bend	_	Grain		<u> </u>	Ovalized		\vdash	Pressure/Forced
1.	-	Centre No	ot Concei	ntric to	o/s _	BOM/Route		Hardwa		_	Over/Under		-	Temperature/Cure
	┢──	Cracks			<u> </u>	Broken/Damaged	-	1	ion Incomplete		Part Incorre		-	Weld
	-	Crushed/	Crimped,		<u> </u>	Burrs	-	1	tions Incomplete	/Unclear	Part Lost/M	issing	Ш'	Wrong Stock Pulled
	<u> </u>	Cuffs			<u> </u>	Contamination	-	Mainte		<u> </u>	Part Moved			•
	<u> </u>	Heat Trea			<u> </u>	Countersink	<u> </u>	Mislabe		<u> </u>	Positioned \	-		-
•	-	Inspection		Tube	<u> </u>	Cut Too Short	\vdash	Misread	d		Power Loss/	Surge		Other
	<u> </u>	Ripples in			<u> </u>	Drill Holes	\vdash	Offset						
	_	Torque W			n	Drawing	\vdash	4	Calibration					
	\vdash	Turning S	•		<u> </u>	Finish			Sequence					
i		Wave/Tw	ist in Tub)e	i	Folio	1	Mutside	Dimensions					

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90577

Page 2

Wednesday, Sep	tember 19, 20	012 11:55:42 A		9(1:)	<i>' '</i>	_			1 age 2	
Item ID: Revision ID:	D412-698-0	35		Accept	*N900	04010	()* Setu	p Start	*NS1*	
Item Name:	Door Handle							Stop	*NS2*	
Start Date:	9/19/2012	Start Qty: 1.00	*1*		Cust Item I	D:	•			
Required Date:	: 9/19/2012	Req'd Qty: 1.00	*1*		Customer:		,			
Approvals:	Process Pla	nn:	Date:	Tooling:	Da	nte:	Run		"NR1"	
	QC:		Date:	_ SPC (Y/N):	Da	nte:	-	Stop	*NR2*	
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool # Plan Code			Reject Insp. Number Stamp	
130 Packaging		Packaging Memo		0.00				// 12 h		
Packaging		Identify and	pack for shipping as per F	DDD D412 (00	1P			e soft	//?(1)	
140		QC21- Final Inspection -	Work Order Release	0.00						
*14 ∩ *		Memo		0.00			M	してい	2-09-19	
Quality Control										
									MM/	

MY (2-09-19

					•					DQA:	Date:	
NCR: Y	es ,	/ No				WORK ORDER NON-O	CONFOR	MANCE / U				
										QA Closed:	Date:	
Work Orde	er:					DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part N	_					Rework Scrap	4 1	Skid-tube Machining	Crosstube Small Fab		Water Jet d. Eng. Coor.	Engineering Quality Other
NCR N	10. <u> </u>			·		Use-as-is Work Order Update	i inem	noforming	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other
Root					Descrip	otion of work order update	Initial	Δ	ction	Sign &		
Cause		Date	Step	Qty	C	or Non-conformance	Chief Eng	Des	scription	Date	Verification	QC Inspector
Doc/Data		·										
Equip/Tooling						•			!			
Operator												
Material												
Setup												
Other												
Process												
Supplier												·
Training											ŀ	
Unapproved												
						F	AULT CATE	GORY				
Landir	ng Ge	ar				General						

Cracks Broken/Damaged Inspection Incomplete Weld Part Incorrect Crushed/Crimped. Instructions Incomplete/Unclear Burrs Part Lost/Missing Wrong Stock Pulled Cuffs Maintenance Part Moved Contamination Heat Treat Countersink Mislabeled Positioned Wrong Inspection Strip in Tube Cut Too Short Misread Power Loss/Surge Other Ripples in Bend Drill Holes Offset Torque Waves in Extrusion Drawing Out of Calibration Turning Sequence Finish Out of Sequence Folio Wave/Twist in Tube **Outside Dimensions**

Grain

Hardware

Pressure/Forced

Temperature/Cure

Ovalized

Over/Under tolerance

Bend

BOM/Route

Bending

Centre Not Concentric to O/S

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Wednesday, September 19, 2012 11:55:42

Work Order ID:

90577

Parent Item:

D412-698-035

Parent Item Name:

Door Handle

Start Date: 9/19/2012

Required Date: 9/19/2012

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total J Qty	Qty Issued	Date Issued	Status
AN525-832R8		Purchased	No			120	Each	114.0000	12	12	20		
				Location		Loc Oty	<u>L</u>	oc Code			U		
				ST345		14							
		··			8583	1							
					0308	13			12	0308			
				T344		100							
AN960JD10L	NAS1149D0332J		N	122	2814	100	-		77	2	,		
Washer	NAS1149D0332J	Purchased	No			120	Each	0.0000	12/22	2973 12	13		
D3779±041		Manufactured	No			120	Each	4.0000	2	2			
Handle Assembly (Exterior)											-13-		
				Location		Loc Qty	Ī	oc Code			,		
				ST234		4							
				874	481	4			8,	7481			
Handle Assembly (Interior)		Manufactured	No			120	Each	3.0000		2	7 3 3	>	
				Location		Loc Qty	L	oc Code					
				ST081		-3							
				ST234		3							
					168 507	1			07	110			
/ •				873 ST234A	307	2				1507			
D3779-3		M	No	31234A		120	Each	9 0000	6				
Plate		Manufactured	110			120	Each	8.0000	V.35	2	JB.		12/0
				Location		Loc Oty	L	oc Code			v		•
				ST062		8			 ;	629			
					539 189	5			<u> </u>	539	•		

												DQA:	D.	ate: _	
NCR:	Yes /	No				WORK ORDER NON-	COI	NFORM	MANCE / UP	DATE			-		
										· · · · · · · · · · · · · · · · · · ·	_	QA Closed:	D	ate:	
Work Ord	er·					DISPOSITION				AGAINST [ЭE	PARTMENT	PROCESS		
Part	-					Rework Scrap		I	Skid-tube Machining	Crosstube Small Fab		- Pro	Water Je d. Eng. Coor	\vdash	Engineering Quality
NCR I	No					Use-as-is Work Order Update		1	noforming Large Fab	Finishing Composite	_	Rec/Stoi	e/Packaging Supplie	~	Other
Root					Descri	ption of work order update		Initial	Ac	ction	_	Sign &			
Cause	C	ate	Step	Qty	,	or Non-conformance	Ch	nief Eng	Desc	ription		Date	Verificati	on	QC Inspector
Doc/Data							Π								
Equip/Tooling															
Operator				,											
Material															
Setup					8										
Other														İ	
Process															
Supplier															
Training															
Unapproved *			*												
						F	AUL	T CATE	GORY		_				
Landi	ing Gear	•				General		-				_			
	Ber	nding				Bend		Grain				Ovalized			Pressure/Forced
	Cer	ntre No	t Conce	ntric to	o/s	BOM/Route		Hardwa	re			Over/Under	tolerance		Temperature/Cure
	Cra	cks				Broken/Damaged		Inspecti	on Incomplete	Ĺ		Part Incorre	ct		Weld
	Cru	shed/0	Crimped.			Burrs	L	Instruct	ions Incomplete	/Unclear	_	Part Lost/M	issing		Wrong Stock Pulled
1	Cuf	fs				Contamination					Part Moved				

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

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Wednesday, September 19, 2012 11:55:42

Work Order ID:

90577

Parent Item:

D412-698-035

Start Date: 9/19/2012

Required Date: 9/19/2012

Parent Item Name:	Door Handle						Start	Qty: 1.00		Required Qty	1.00
MS21022L3 Nut		Purchased	No		120	Each	2,645.0000	12	12	JB	
1				Location	Loc Oty		Loc Code			,	
				316	719						
				122452	719						
				ST300	574						
				117885	32						
				119017	404						
				119075	138						•
				ST317	1352						
				122141	1352			12:	2141		
MS24694-S5		Purchased	No		120	Each	53.0000	12 _/[68		JB	12/09/19
al .				Location	Loc Oty		Loc Code			-	, ,
M.				ST289A	53						
•				116540	6						
				120308	47			+20	308		

												DQA:	Date:	:	
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFOR	MANCE / UP	DATE					
											QA CI	osed:	Date	:	
Work Orde	or.					DISPOSITION				AGAINST D	EPARTI	ΛENT,	/PROCESS		
Work Orde	C1.		······································	<u>-</u>		Rework	7		Skid-tube	Crosstube	7		Water Jet	Engineering	
Part N	۷n					Scrap	1]	Machining	Small Fab	+	Pro	d. Eng. Coor.	Quality	\dashv
1 4.61					· · · · · · · · · · · · · · · · · · ·	Use-as-is	1	B	noforming	Finishing	⊢ Re		re/Packaging	Other	\dashv
NCR N	Vo.					Work Order Update	1		Large Fab	Composite	┥ ¨``	0,010	Supplier	1	\dashv
									• —						
Root					Descri	ption of work order update		Initial	Ac	tion	Sign	า &			
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Desc	ription	Da	ite	Verification	QC Inspect	or
Doc/Data															
Equip/Tooling															
Operator															
Material															
Setup			ļ						:		1				
Other	L														
Process				·						·					
Supplier															
Training															
Unapproved	-				ļ		<u> </u>								
							AUI	T CATE	GORY						
Landii	ng (1				General		1		Г	٦		۲	7	_
		Bending			<u> </u>	Bend	\vdash	Grain			Ovaliz		-	Pressure/Forced	
	-	Centre No	ot Concer	ntric to	U/S	BOM/Route	\vdash	Hardwa		<u> </u>	 `		tolerance	Temperature/Ci	ıre
	\vdash	Cracks	C		ļ	Broken/Damaged	\vdash	1 '	on Incomplete	,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,	Part Ir		j	Weld	
1		Crushed/	crimped.			Burrs	1	Instruct	ions Incomplete/	Unclear	Part L	ost/M	issing	Wrong Stock Pu	lled

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Part Moved

Positioned Wrong

Power Loss/Surge

Other

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Cuffs

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

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8.0 PARTS LIST - CABIN DOOR MODIFICATION KITS

(FOR AIRCRAFT EQUIPPED WITH P/N 412-030-300-XXX COMPOSITE DOORS)

D412-698-019 BEARING OVERHAUL KIT	Qty	Qty	Qty	Qty -032	Qty -033	Qty -035	Part Number	Description
X D412-698-021 REPLACEMENT SHIM KIT	-019	-021	-031	-032	-033	-035		
X	X							
X		X						
X D412-698-033 REPLACEMENT DOOR TRACK KIT	L		X					
X D412-698-035 DOOR HANDLE KIT				X				
D3121-21 BOLT					X			
D3121-241 BEARING ASSEMBLY						X	D412-698-035	DOOR HANDLE KIT
D3121-241 BEARING ASSEMBLY	7						D3121-21	BOLT
D3137-3 GUIDE		ļ. <u></u>						
D3137-5						<u> </u>		GUIDE
D3183-045 BEARING ASSEMBLY D3238-1 SHIM D3238-3 SHIM D3238-5 SHIM D3238-11 SHIM D3238-11 SHIM D3238-13 SHIM D3238-13 SHIM D3238-15 SHIM D3238-15 SHIM 1 D3121-143 BRACKET ASSEMBLY D3121-144 BRACKET ASSEMBLY D3183-043 BRACKET ASSEMBLY D3183-043 BRACKET ASSEMBLY D3183-044 BRACKET ASSEMBLY D3183-045 BRACKET ASSEMBLY D3183-044 BRACKET ASSEMBLY D3								WASHER
3 D3238-1 SHIM D3238-3 SHIM D3238-5 SHIM 6 D3238-11 SHIM 2 D3238-11 SHIM 2 D3238-13 SHIM 4 D3238-15 SHIM 1 D3121-143 BRACKET ASSEMBLY D3121-144 BRACKET ASSEMBLY 1 D3121-144 BRACKET ASSEMBLY 1 D3183-043 BRACKET ASSEMBLY 1 D3183-044 BRACKET ASSEMBLY 1 D3183-044 BRACKET ASSEMBLY 1 D3183-044 BRACKET ASSEMBLY 1 D3202-3 COVER 3 3 3 D3674-041 BRACKET ASSEMBLY 9 9 9 D3675-1 BRACKET 2 D3779-041 HANDLE ASSEMBLY 2 D3779-043 HANDLE ASSEMBLY 1 AN525-832R8 SCREW 4 12 AN960JD10L WASHER								
D3238-3								
D3238-5								
D3238-11								
D3238-13 SHIM D3238-15 SHIM 1 D3121-143 BRACKET ASSEMBLY D3121-144 BRACKET ASSEMBLY D3137-043 BRACKET ASSEMBLY D3183-043 BRACKET ASSEMBLY D3183-044 BRACKET ASSEMBLY D3202-3 COVER D3674-041 BRACKET ASSEMBLY D3675-1 BRACKET D3779-041 HANDLE ASSEMBLY D3779-041 HANDLE ASSEMBLY D3779-043 HANDLE ASSEMBLY D3779-043 SCREW D3779-043 NUT		2					L	
D3238-15 SHIM D3121-143 BRACKET ASSEMBLY D3121-144 BRACKET ASSEMBLY D3137-043 BRACKET ASSEMBLY D3183-043 BRACKET ASSEMBLY D3183-044 BRACKET ASSEMBLY D3674-041 BRACKET ASSEMBLY D3674-041 BRACKET D3779-041 HANDLE ASSEMBLY D3779-041 HANDLE ASSEMBLY D3779-043 HANDLE ASSEMBLY D3779-043 SCREW D3779-043 NUT								
1 D3121-143 BRACKET ASSEMBLY 1 D3121-144 BRACKET ASSEMBLY 1 D3137-043 BRACKET ASSEMBLY 1 D3183-043 BRACKET ASSEMBLY 1 D3183-044 BRACKET ASSEMBLY 1 D3183-044 BRACKET ASSEMBLY 1 D3202-3 COVER 1 D3674-041 BRACKET ASSEMBLY 9 9 D3675-1 BRACKET		2						
1 D3121-144 BRACKET ASSEMBLY D3137-043 BRACKET ASSEMBLY 1 D3183-043 BRACKET ASSEMBLY D3183-044 BRACKET ASSEMBLY 1 D3202-3 COVER 3 3 D3674-041 BRACKET ASSEMBLY 9 9 9 D3675-1 BRACKET		4					D3238-15	SHIM
1 D3121-144 BRACKET ASSEMBLY D3137-043 BRACKET ASSEMBLY 1 D3183-043 BRACKET ASSEMBLY D3183-044 BRACKET ASSEMBLY 1 D3202-3 COVER 3 3 D3674-041 BRACKET ASSEMBLY 9 9 9 D3675-1 BRACKET			1				D3121-143	BRACKET ASSEMBLY
1 1 D3137-043 BRACKET ASSEMBLY D3183-043 BRACKET ASSEMBLY BRACKET ASSEMBLY D3183-044 BRACKET ASSEMBLY COVER D3183-044 BRACKET ASSEMBLY D3202-3 COVER BRACKET ASSEMBLY D3674-041 BRACKET ASSEMBLY D3675-1 BRACKET BRACKET D3779-041 HANDLE ASSEMBLY D3779-043 PLATE D3779-043 HANDLE ASSEMBLY D3779-043 SCREW D3779-043 NUT			'	1				
1 D3183-043 BRACKET ASSEMBLY D3183-044 BRACKET ASSEMBLY 1 1 D3202-3 COVER 3 3 D3674-041 BRACKET ASSEMBLY 9 9 9 D3675-1 BRACKET			1					
1 1 1 D3183-044 BRACKET ASSEMBLY 1 1 1 D3202-3 COVER 3 3 D3674-041 BRACKET ASSEMBLY 9 9 9 D3675-1 BRACKET				-				BRACKET ASSEMBLY
1 1 1 D3202-3 COVER 3 3 D3674-041 BRACKET ASSEMBLY 9 9 9 D3675-1 BRACKET /2 D3779-041 HANDLE ASSEMBLY /2 D3779-043 PLATE /2 D3779-043 HANDLE ASSEMBLY /12 AN525-832R8 SCREW /12 AN960JD10L WASHER /12 MS21042L37 NUT			<u>'</u>	1				
3 3 D3674-041 BRACKET ASSEMBLY 9 9 9 D3675-1 BRACKET /2 D3779-041 HANDLE ASSEMBLY -2 D3779-3 PLATE /2 D3779-043 HANDLE ASSEMBLY /12 AN525-832R8 SCREW /12 AN960JD10L WASHER /12 MS21042L37 NUT			1		1			
9 9 9 D3675-1 BRACKET /2 D3779-041 HANDLE ASSEMBLY /2 D3779-3 PLATE /2 D3779-043 HANDLE ASSEMBLY /12 AN525-832R8 SCREW /12 AN960JD10L WASHER /12 MS21042L37 NUT		 			 	 		
		 			9	-		
12 D3779-3 PLATE			<u> </u>			70	D0770 047	LIANDI E ACCEMBI V
12 AN525-832R8 SCREW 4—12—-AN960JD10L WASHER 712 MS21042L37 NUT						F		
12 AN525-832R8> SCREW 4—12—AN960JD10L > WASHER 712 MS21042L37 NUT					-			
2 —12 — AN960JD10L						1.2-	_D3/./.9-043 /	HANDLE ASSEMBLY
712 MS21042L37 NUT			 	 -	<u> </u>	1 12	AN525-832R8>	SCREW
712 MS21042L37 NUT		 	 		- 2	12	-AN960JD10L フ	WASHER
				 				NUT
12 MS24694-S58 SCREW						12	MS24694-S58	SCREW
1 MS24694-S101 SCREW	1			† — — ·				SCREW

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Revision: **E**

Date: 08.05.01

DART SERVICE INSTRUCTION TO AMEND INSTALLATION INSTRUCTIONS

TO AMEND INSTALLATION INSTRUCTIONS
IIN-D412-698 REV. E OR EARLIER AND INSTRUCTIONS FOR
CONTINUED AIRWORTHINESS ICA-D412-698 REV. 5 OR EARLIERE ONLY
REF CANADIAN STC: SH92-43

REFERENCE ONLY

REF FAA STC: SR01446NY REF EASA STC: EASA.IM.R.S.00709 REF ANAC-BRASIL STC: 2010S10-09

1.0 PURPOSE

Field installations have shown that the screws used to mount D3779-041 Exterior Door Handles as part of the D412-698-035 Door Handle Kit are too long. The MS24694-S58 screws that were originally provided in the kit should be replaced with MS24694-S51 screws.

2.0 CHANGE:

8.0 PARTS LIST - CABIN DOOR MODIFICATION KITS (IIN-D412-698) 52.18 PARTS LIST - CABIN DOOR MODIFICATION KITS (ICA-D412-698)

QTY -035	P/N	DESCRIPTION
Х	D412-698-035	DOOR HANDLE KIT

IS:

	THE COLUMN TWO IS NOT THE OWNER.	
12	MS246945S51	SCREW

WAS:

12	MS24694-S58	SCREW

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

DATE: 12.04.26 CERT. NO.: SH92-43 ISSUE NO.: 5

Α	NEW IS	12.04.26			
REV.	DESCRIPTION BY				DATE
DESIGN		RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN		RP			
CHECKED		al	DSI 9609		REV. A
MFG. APPR.		Œ			SHEET 1 OF 2
APPROVED		Juff	TITLE EXTERIOR DOOR HANDLE KIT UPDATE		SCALE
DE APPR.		-##-			NTS
DATE 12.04.26			COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND COMPETENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PUMPOSE OR COPED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		